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D3564-13
Job Sheet 196311



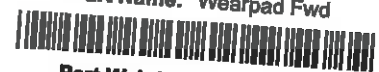
Part No: D3564-13

Part Name: Wearpad Fwd

Job Qty: 6 pcs

15

DAS
21



Part Weight: 0 lbs

Job Created: 6/11/19

Due Date: 7/12/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	6		7/12/19	0.17	0.46	Waterjet - Flow			DAS 69 9-89 7/5/19
		pcs								
120	QC 8	6		7/12/19	0.00	0.00	QC 8 - 12			DAS 40 9-89 JUL 03 2019
		pcs					QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			DAS 30 JUL 17 2019
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			
130	Small Fab - Brake NC - B4B	6		7/12/19	0.25	0.14	Small Fab - Brake - 1 - B4B			
		pcs					Small Fab - Brake - 2 -			

				B4B	
				Small Feb - Brake - 3 - B4B	
140 QC 5	6 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS 40
					9-89
150 Spray Paint - 2 - B4B	6 pcs	7/12/19	0.00 0.03	Spray Paint - 1 - B4B	JUL 18 2019
				Spray Paint - 2 - B4B	AS 19-7-18
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160 QC 5	6 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS 40
					9-89
170 Packaging 3-1 - Stock - B4B	6 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	JUL 22 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6	7/12/19	0.00 0.00	QC 21 - SA - 21	JUL 25 2019
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - (QC8- inspect parts - second check)
Descriptions: 130 - (Form as per dwg)
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Spray Paint / NDT Room) 5194717
160 - (QC5- Inspect part completeness to step on W/O)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.3320 sf (.222 ea)	100-Waterjet - Flow - 1	519460 x 1 5159674 x 14

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	295	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	7.000inches ± 0.030	7.030 6.970	7.000	
2	Wearshoe	2.285inches ± 0.010	2.295 2.275	2.286	
3	Wearshoe	3.080inches ± 0.010	3.090 3.070	3.077	
4	Wearshoe	3.500inches ± 0.010	3.510 3.490	3.500	
5	Wearshoe	0.300inches ± 0.010	0.310 0.290	0.302	
6	Wearshoe	0.300inches ± 0.010	0.310 0.290	0.300	
7	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187	0.189	
8	Wearshoe	7.750inches ± 0.030	7.780 7.720	7.751	
9	Wearshoe	0.062inches ± 0.010	0.072 0.052	0.061	

Plex 6/11/19 1:40 PM Dart.lajeunesse.marie



NCR No. _____		Job: _____		Part No. _____	
Date: _____		Sequence #: _____		QTY Affected: _____	
DISPOSITION		DEPARTMENT/PROCESS			
Rework Scrap Use-as-is		Cross tube Small Fab Finishing Skid-tube Machining Large Fab Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator Manufacturing Process Equip/Tooling Handling/Presservation Material Product Improvement Process Improvement Human Factors		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			